



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200

PRELIMINARY ISSUE

D5571-1
Job Sheet 179938

Accounting Job RD17-1048-01



Part No: D5571-1

Job Qty: 4 ea

Part Name: Saddle



Part Weight: 0 lbs

Job Created: 6/26/18

Due Date: 7/3/18

Type: R+D

Status: Scheduled

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Note: D5571 REV.PRELIM-A7 IPP REV:A 18.06.12 NEW ISSUE DD VERF:JFS

Ship Via:

POSITIVE RECALL

EFFECTIVE JUN 26 2018

RELEASED 9 DATE 10-10-04

PRIORITY: Medium

9-89

@RwA

ECU13-817

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		7/3/18	0.00	0.00	Start Up Machining-4		
110	CNC Vertical Machining	4 pcs		7/3/18	0.00	2.67	HAAS 5 Axis		18-07-16
120	QC	4 pcs		7/3/18	0.00	0.00	QC2 Machining-4		38
130	QC	4 pcs		7/3/18	0.00	0.00	QC8 Machining-4		38
140	HandFinish	4 pcs		7/3/18	0.00	0.40	HandFinish1		D.R 18/09/14
150	QC	4 pcs		7/3/18	0.00	0.00	QC7-5		38
160	Packaging	4 pcs		7/3/18	0.00	0.00	Packaging3-2		9-89 N/A 14/10/12
170	QC21-SA	4 Ea		7/3/18	0.00	0.00	QC21		

Part Op 110 - 1-Machine per folio FC101 DWG REV: FOLIO REV: 2- Deburr and break all sharp edges

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7050-T7451-P4.50X6.25X10.50	7050 Aluminum Plate, 4.5" Thick x 6.25" Wide x 10.50" Long	4 Ea (1 ea)	90-Start up Operation	S092438

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7050-T7451-P4.50X6.25X10.50	4	10	0

Part Specifications

Specifications could not be found.

Plex 6/26/18 2:25 PM Dart.lajeunesse.marie

152 Spray Paint

154 QC14

M7050-P4.50X6.25X10.50
S061608



1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32

Part: D5571-1

Job No: 179938

Serial No/Batch: S092439

Revision: A7

Inspector:

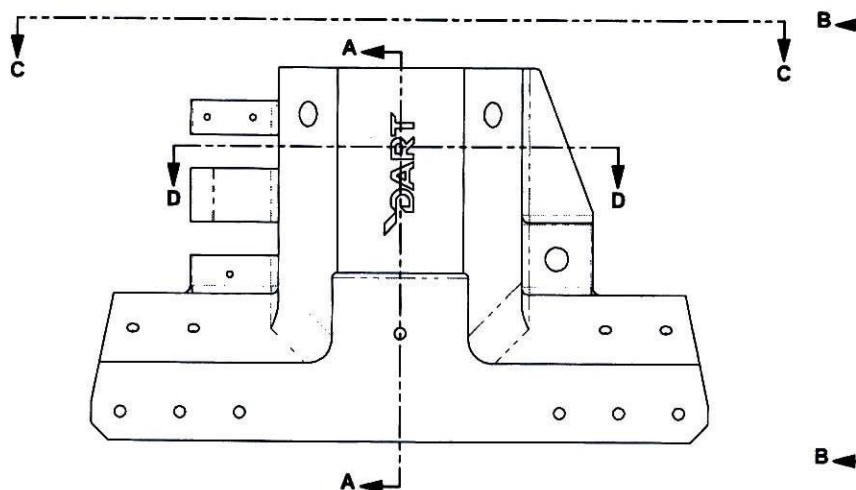
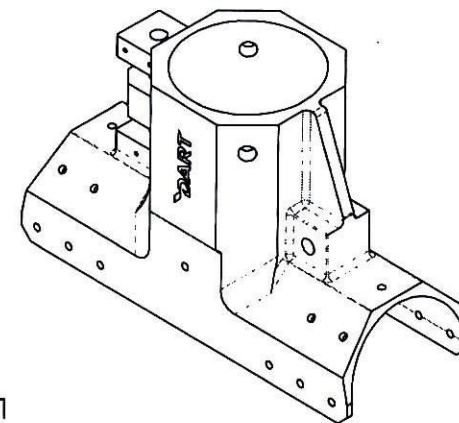
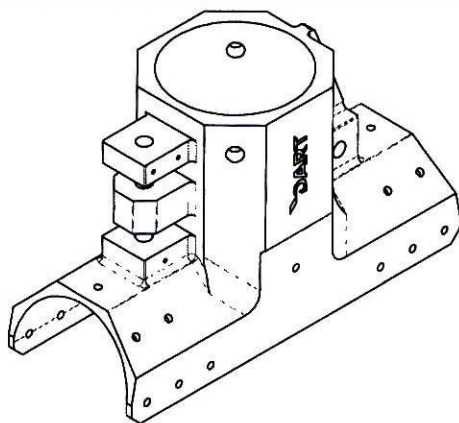
Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/16/18

REVISED	DATE	BY	EFFECTIVE
	07-08	06C	



D5571-1 EC 130 SADDLE

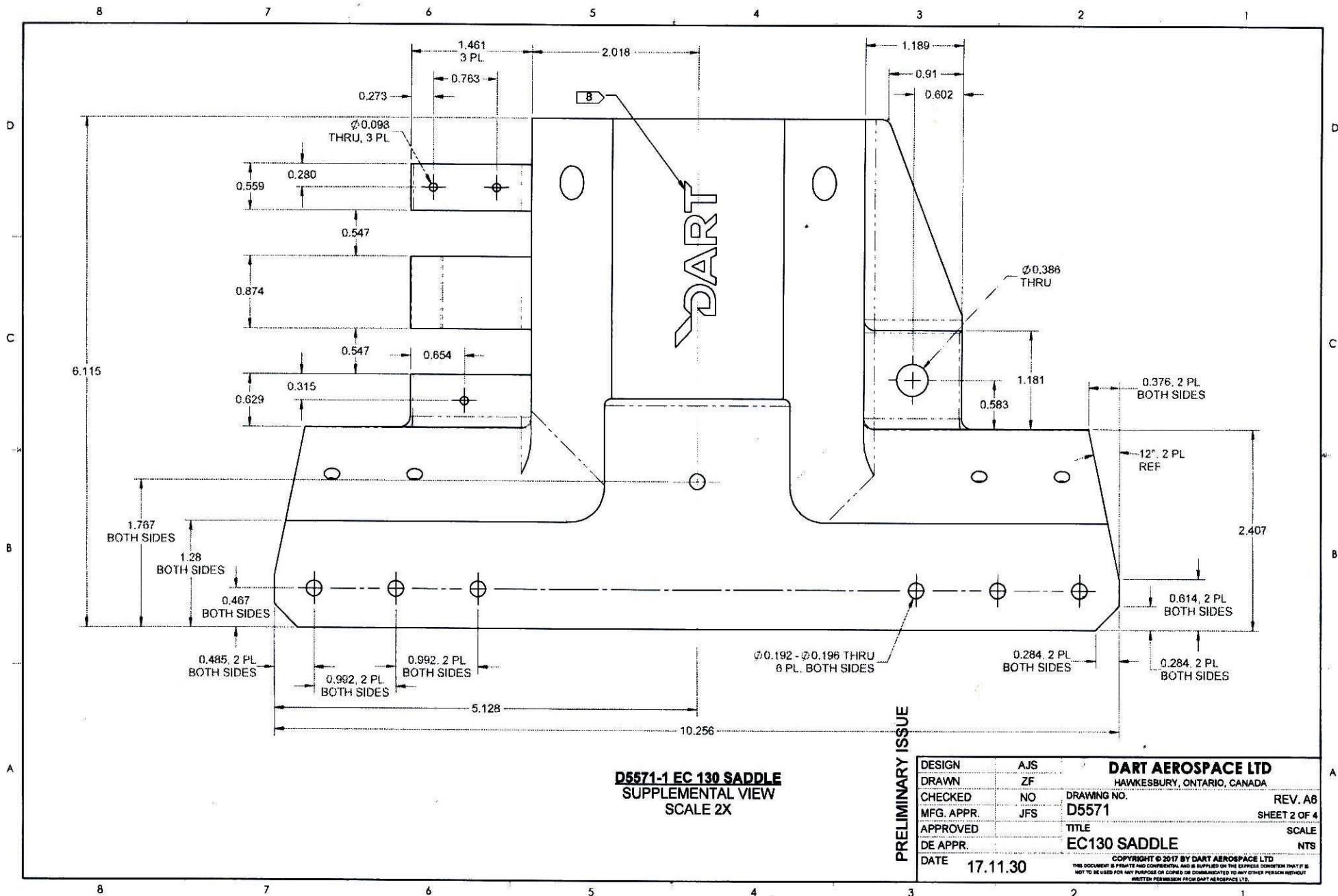
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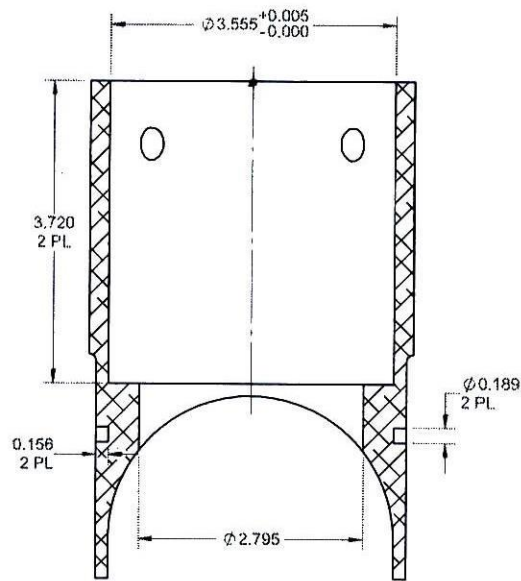
- 1) MATERIAL: 7050 (OR T7451/T7851) ALUMINUM PLATE
PER AMS 4050 (T7451) OR
PER AMS 4021 (T7851)
REF DART SPEC M7075-T7451-P4.50X6.25X10.50 OR
REF DART SPEC M7075-T7851-P4.50X6.25X10.50
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER)
PAINT OUTSIDE PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044, 6.1
- 7) WEIGHT: 3.84 lbs
- 8) ENGRAVE "DART" LOGO AS SHOWN 0.010 - 0.012 DP WITH A MINIMUM 0.010 RAD
- 9) ALL NON DIMENSIONED FEATURES PER CAD FILE "D5571-1-REVA.STP"

**SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 179938 MWS
18-06-26**

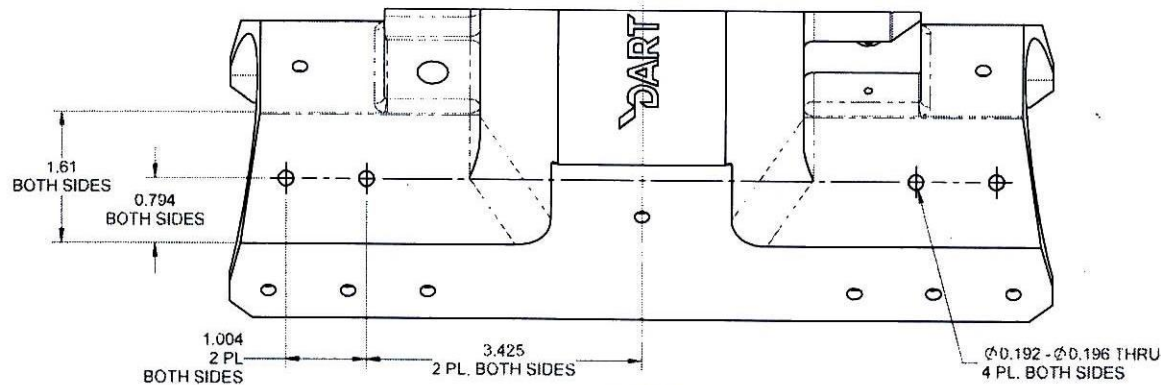
PRELIMINARY ISSUE

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	AJS	17.11.30
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	NO	DRAWING NO.	REV. A6
MFG. APPR.	JFS	D5571	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		EC130 SADDLE	NTS
DATE	17.11.30	COPYRIGHT © 2017 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

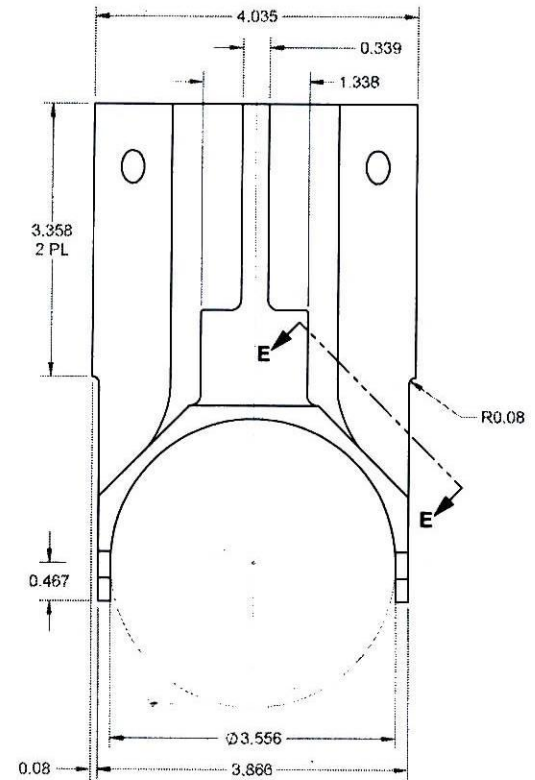




SECTION A-A
SCALE 1.25X



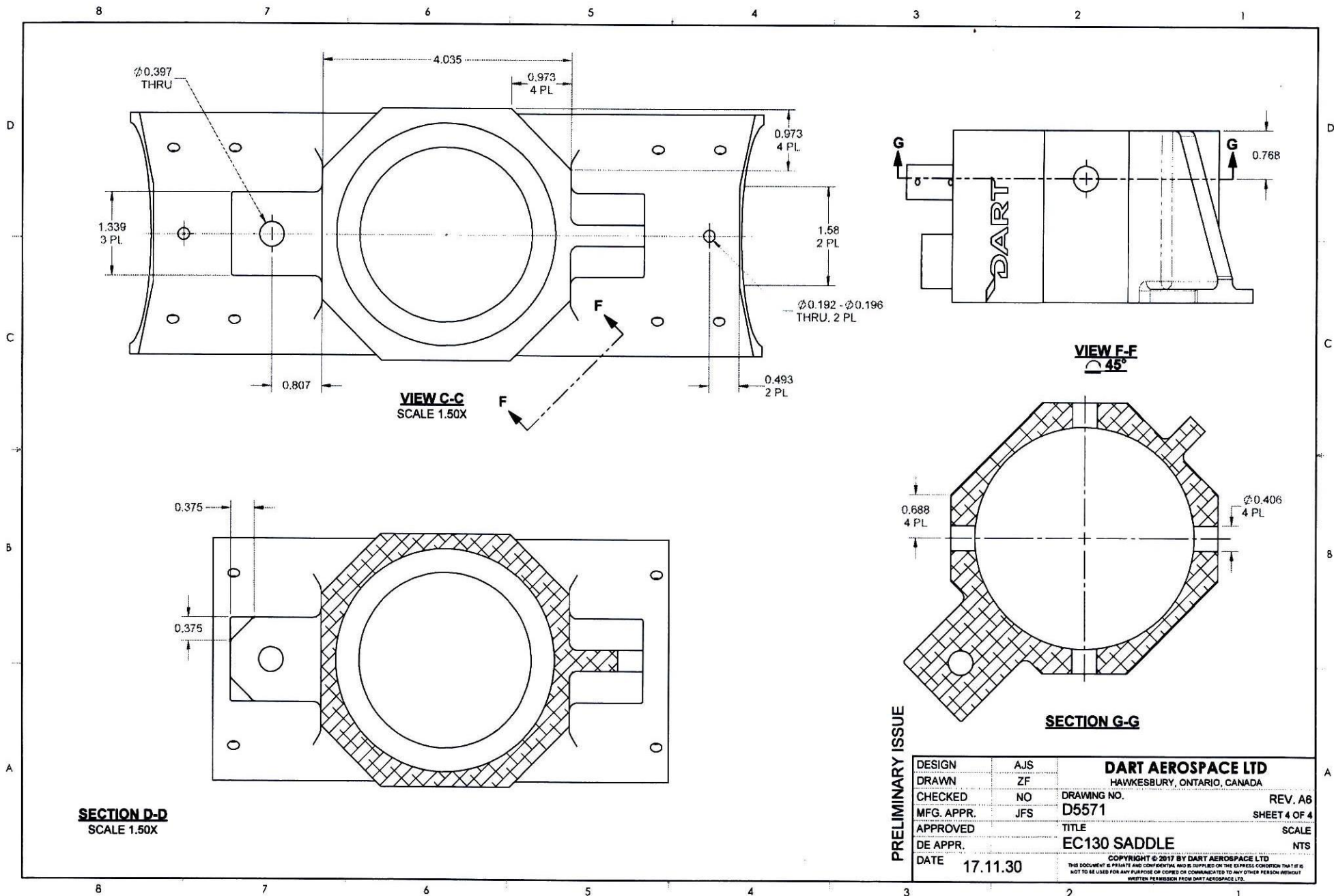
VIEW E-E
SCALE 1.25X



VIEW B-B
SCALE 1.25X

PRELIMINARY ISSUE

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CHECKED	NO	DRAWING NO.	REV. A6
MFG. APPR.	JFS	D5571	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		EC130 SADDLE	NTS
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DART AEROSPACE LTD		Work Order: 179.938
Description:		Part Number: 05571-1
Inspection Dwg:	Rev:	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.018	+/- .010	2.018	✓			
1.461	+/- .010	1.459	✓			
.763	+/- .005	.765	✓			
.273	+/- .010	.272	✓			
Ø .098	+ .004 / - .001	.100	✓			
.280	+/- .010	.280	✓			
.559	+/- .010	.559	✓			
.547	+/- .010	.544	✓			
.874	+/- .010	.874	✓			
.547	+/- .010	.544	✓			
.654	+/- .010	.655	✓			
.315	+/- .010	.313	✓			
.629	+/- .010	.629	✓			
6.115	+/- .010	6.115	✓			
1.767	+/- .010	1.770	✓			
1.28	+/- .030	1.290	✓			
.467	+/- .010	.467	✓			
.485	+/- .010	.485	✓			
.992	+/- .005	.992	✓			
.992	+/- .005	.992	✓			
5.128	+/- .010	5.131	✓			
10.256	+/- .010	10.257	✓			
Ø .192-.196	—	.194	✓			
.284	+/- .010	.284	✓			
.284	+/- .010	.284	✓			
.614	+/- .010	.610	✓			
2.407	+/- .010	2.410	✓			
.376	+/- .010	.376	✓			
1.181	+/- .010	1.1785	✓			
.583	+/- .010	.582	✓			
Ø .386	+ .006 / - .001	.385	✓			
.602	+/- .010	.597	✓			

Measured by: 20	Checked by: 38	QC Inspector:
Date: 18-07-15	Date: SEP 14 2018	Date:

Engineering Approval: (If necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

DART AEROSPACE LTD		Work Order:	
Description:		Part Number:	
Inspection Dwg:	Rev:	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.91	+/- .030	.910	✓			
1.189	+/- .010	1.186	✓			
3.555	+/- .005/- .000	3.558	✓			
3.720	+/- .010	3.728	✓			
.156	+/- .010	.156	✓			
φ .189	+ .005/- .001	.188	✓			
1.61	+/- .030	1.610	✓			
.794	+/- .010	.795	✓			
1.004	+/- .005	1.004	✓			
3.425	+/- .005	3.425	✓			
φ .192-.196	—	.194	✓			
4.035	+/- .010	4.033	✓			
.339	+/- .010	.339	✓			
1.338	+/- .010	1.338	✓			
3.358	+/- .010	3.360	✓			
.467	+/- .010	.467	✓			
.08	+/- .030	.083	✓			
3.866	+/- .010	3.866	✓			
3.556	+/- .010	3.556	✓			
R.08	+/- .030	.090	✓			
4.035	+/- .010	4.037	✓			
.973	+/- .010	.975	✓			
φ .397	+ .006/- .001	.400	✓			
1.339	+/- .010	1.337	✓			
.807	+/- .010	.805	✓			
.493	+/- .010	.491	✓			
φ .192-.196	—	.194	✓			
1.58	+/- .030	1.600	✓			
.973	+/- .010	.975	✓			
.768	+/- .010	.768	✓			
.375	+/- .010	.375	✓			
.375	+/- .010	.375	✓			

Measured by:	20 9-89	Checked by:	38 2-89	QC Inspector:	
Date:	18-07-15	Date:	SEP 14 2018	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

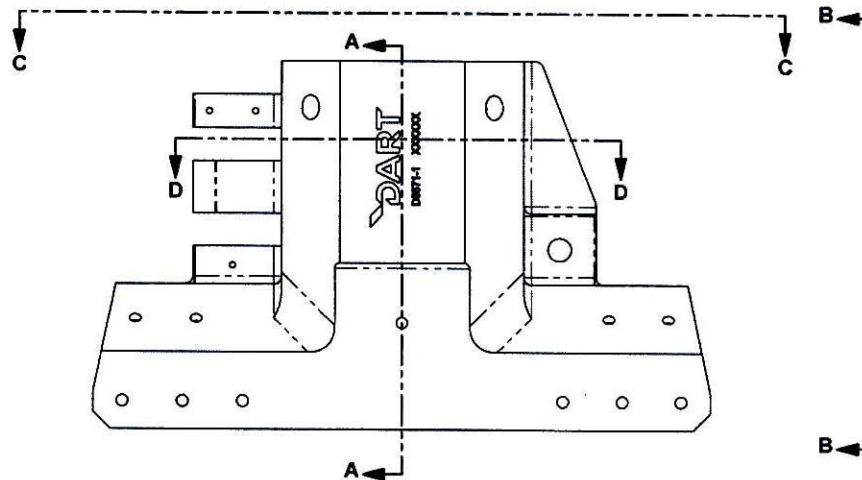
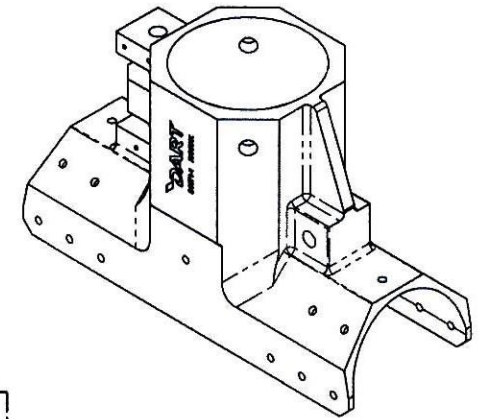
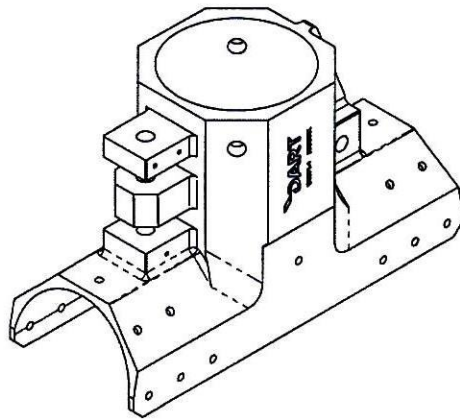
DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					



D5571-1 SADDLE (EC130)

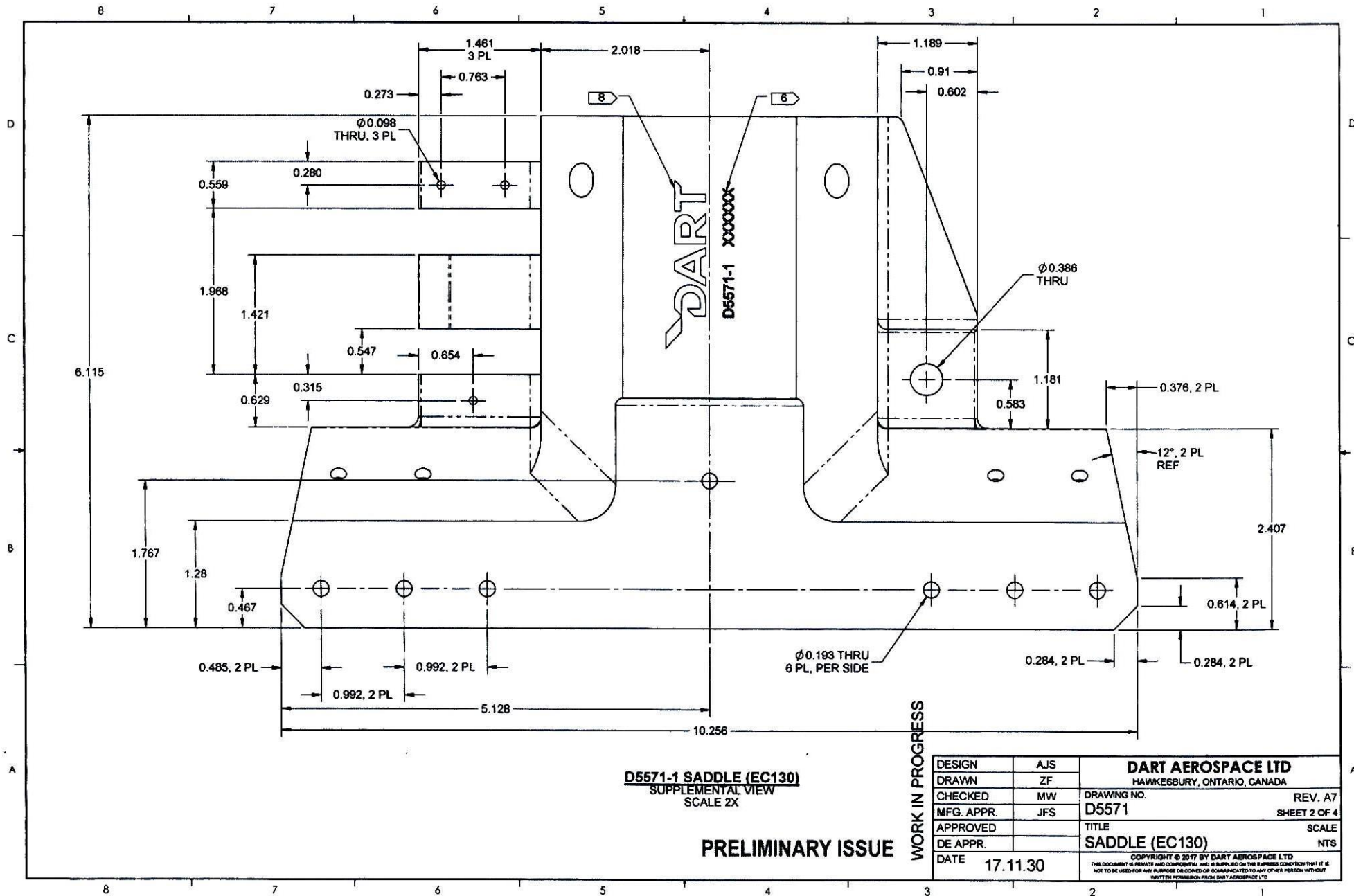
NOTES:

- 1) MATERIAL: 7050-T7451 OR -T7651 ALUMINUM PLATE
PER AMS 4050 (T7451) OR
PER AMS 4201 (T7651)
REF DART SPEC M7050P
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND S/N PER QSI 044 6.3
USE MAX DEPTH 0.010 WITH MIN TOOL RAD OF 0.010
ENGRAVE BOTH SIDES
- 7) WEIGHT: 3.76 lbs
- 8) ENGRAVE DART LOGO AS SHOWN USE MAX DEPTH OF 0.010
WITH A MIN TOOL RAD OF 0.010, ENGRAVE BOTH SIDES
- 9) ALL NON DIMENSIONED FEATURES PER CAD FILE "D5571-1-REVA.STP"

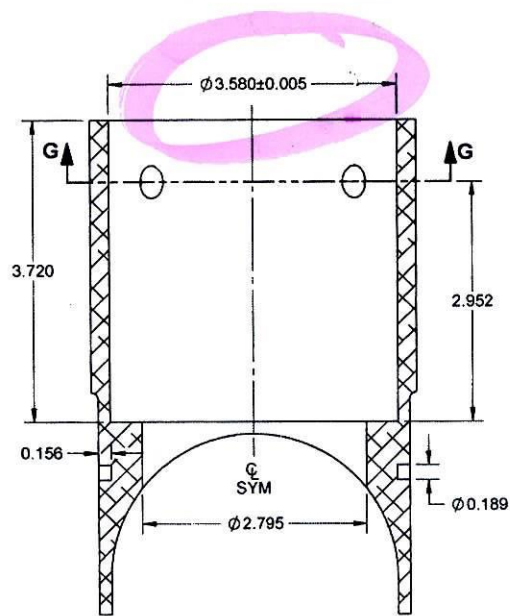
PRELIMINARY ISSUE

WORK IN PROGRESS

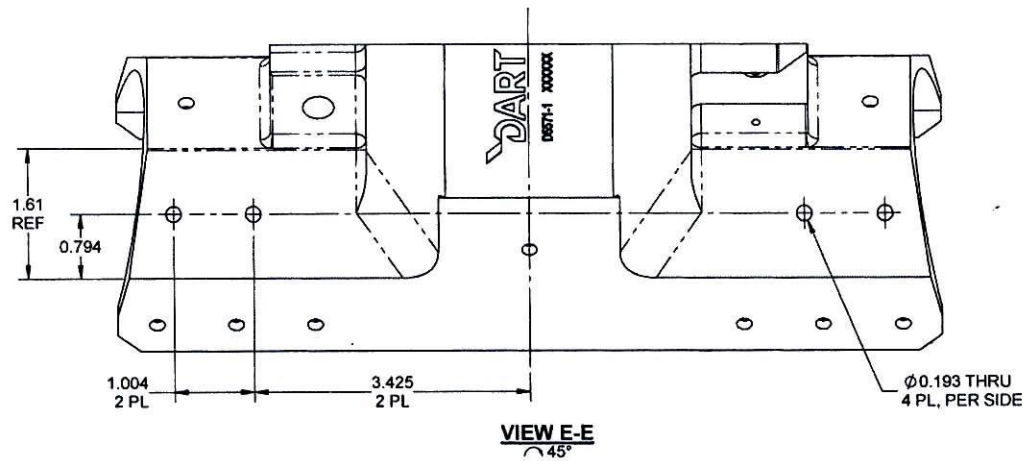
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DRAWN	ZF			SHEET 1 OF 4	
CHECKED	MW	DRAWING NO.		REV. A7	
MFG. APPR.	JFS	D5571		SHEET 1 OF 4	
APPROVED		TITLE		SCALE	
DE APPR.		SADDLE (EC130)		NTS	
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MINDIE TO AG DEG

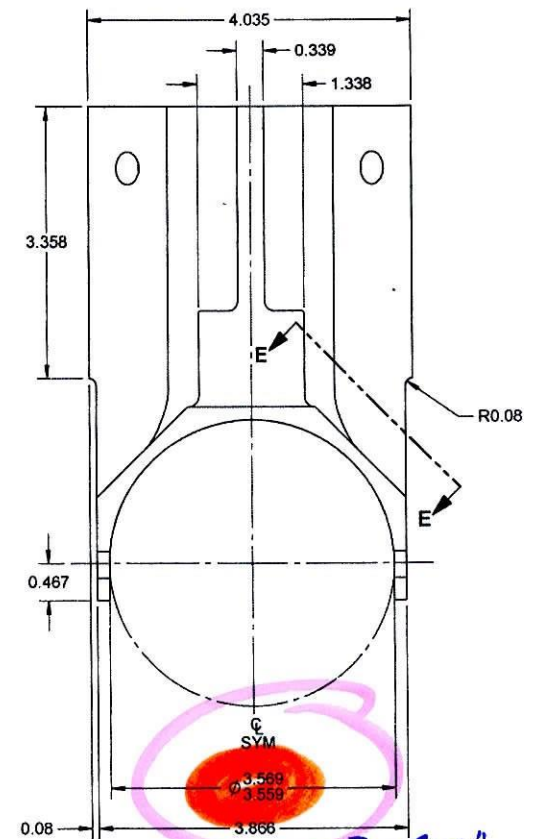


SECTION A-A
SCALE 1.25X



VIEW E-E
45°

PRELIMINARY ISSUE



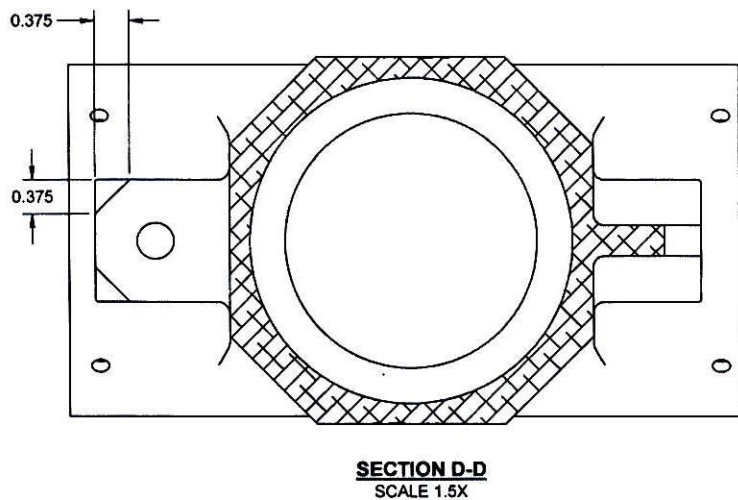
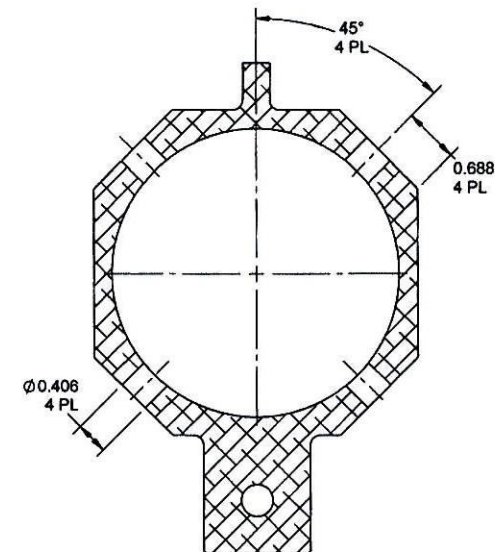
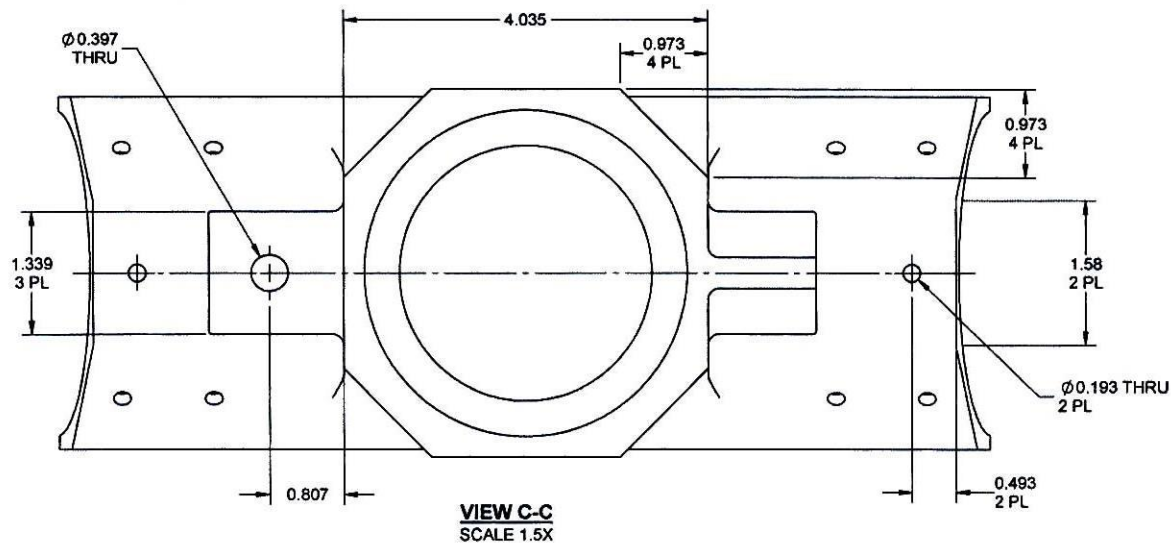
VIEW B-B
SCALE 1.25X

3.550"
3.556

WORK IN PROGRESS

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MW	DRAWING NO.	REV. A7
MFG. APPR.	JFS	D5571	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SADDLE (EC130)	NTS
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8 7 6 5 4 3 2 1



PRELIMINARY ISSUE

WORK IN PROGRESS

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MW	DRAWING NO.	REV. A
MFG. APPR.	JFS	D5571	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SADDLE (EC130)	NTS
DATE	17.11.30	COPYRIGHT © 2017 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

Entered: _____ Date: _____

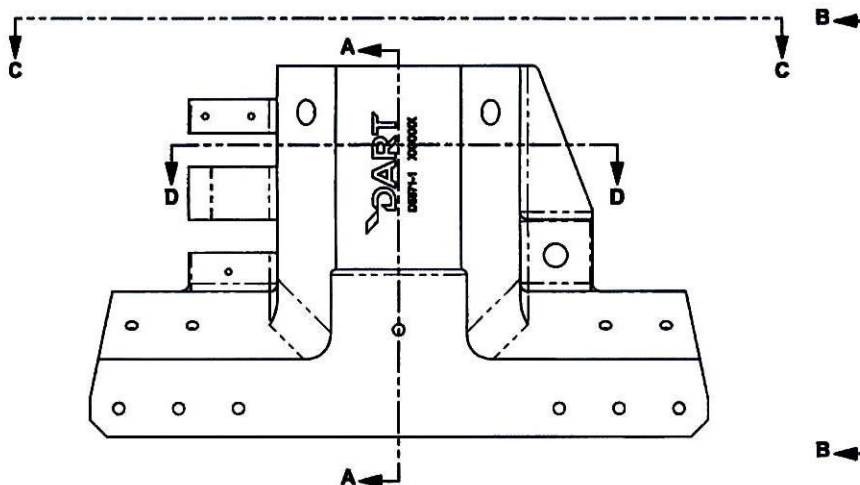
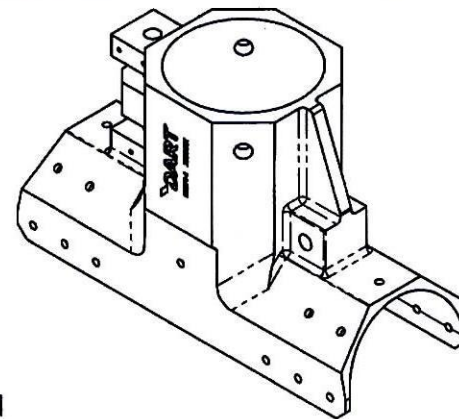
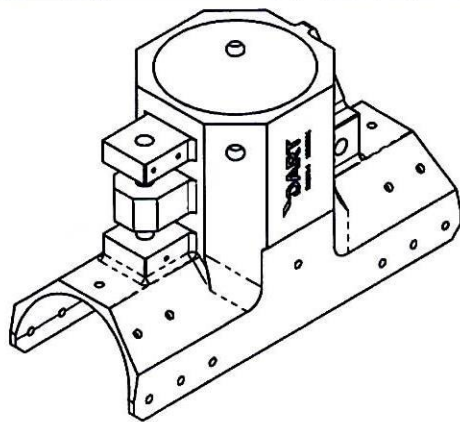


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☒ Water Jet ☐ Supplier ☐ Quality ☐						
Date : 10/10/2		Sequence #:		QTY Affected :		MRB (QSI042)		
Description Work Order Deviation				Disposition				
Saddle was not painted. Crosstube bore and skidtube bore reworked into tolerance (ref. dim $\phi 3.580 \pm 0.005$ & $\phi 3.569$).				Acceptable per D5571 Rev. A.				DAS 12 9-89 10/10/2
								Completed By DAS 12 9-89 10/10/2
								Lead hand / Supervisor DAS 9 9-89 10-10-04
								QC / QA Coordinator DAS 9 9-89 10-10-04
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread						
Other/Details:								



D5571-1 SADDLE (EC130)

NOTES:

- 1) MATERIAL: 7050-T7451 OR -T7851 ALUMINUM PLATE
PER AMS 4050 (T7451) OR
PER AMS 4201 (T7851)
REF DART SPEC M7050-T7451-P4.50X8.25X10.50 OR
REF DART SPEC M7050-T7851-P4.50X8.25X10.50
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND S/N PER QSI 044 6.3
USE MAX DEPTH 0.010 WITH MIN TOOL RAD OF 0.010
ENGRAVE BOTH SIDES
- 7) WEIGHT: 3.76 lbs
- 8) ENGRAVE DART LOGO AS SHOWN USE MAX DEPTH OF 0.010
WITH A MIN TOOL RAD OF 0.010, ENGRAVE BOTH SIDES
- 9) ALL NON DIMENSIONED FEATURES PER CAD FILE "D5571-1-REVA.STP"

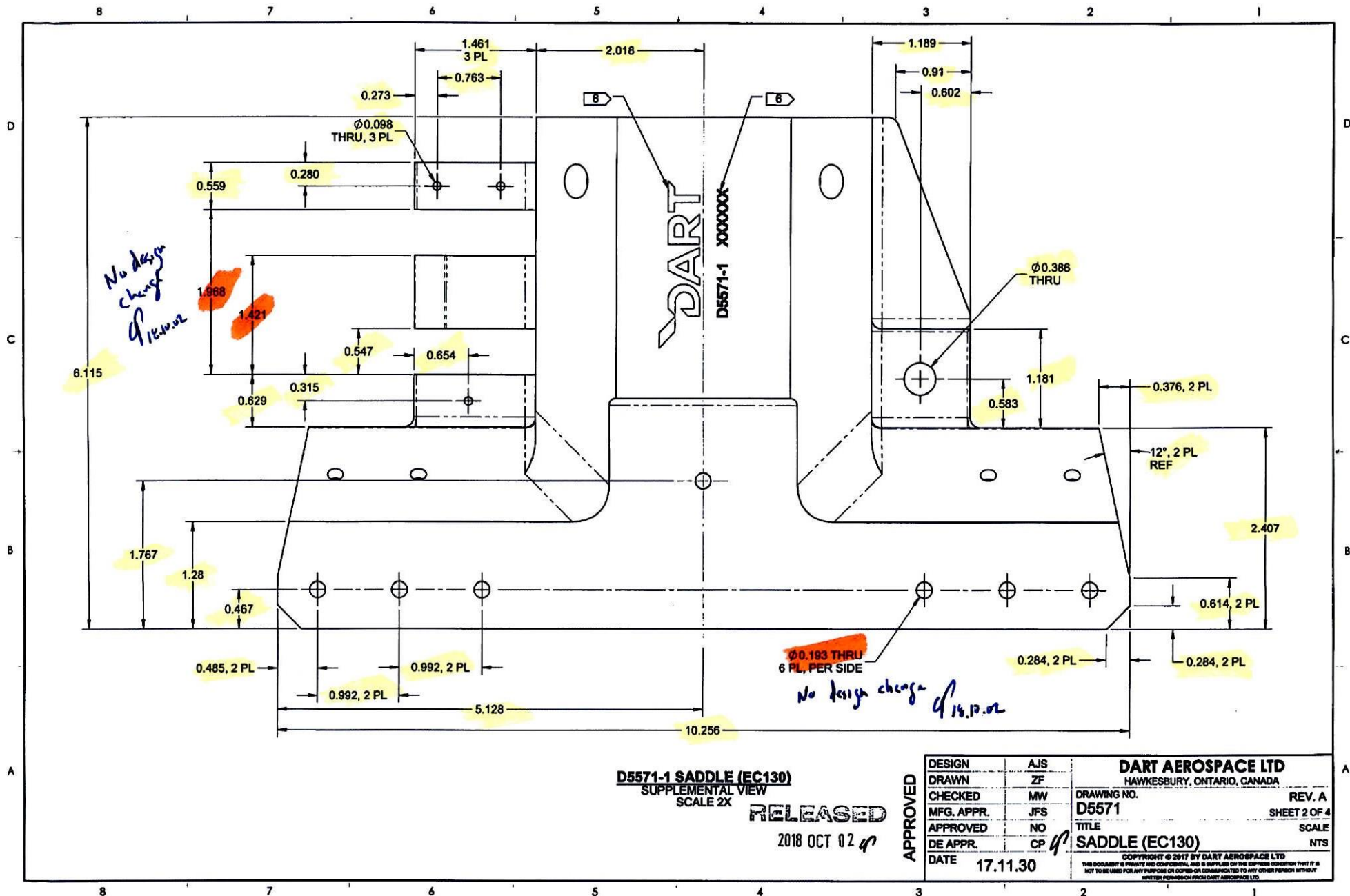
RELEASED

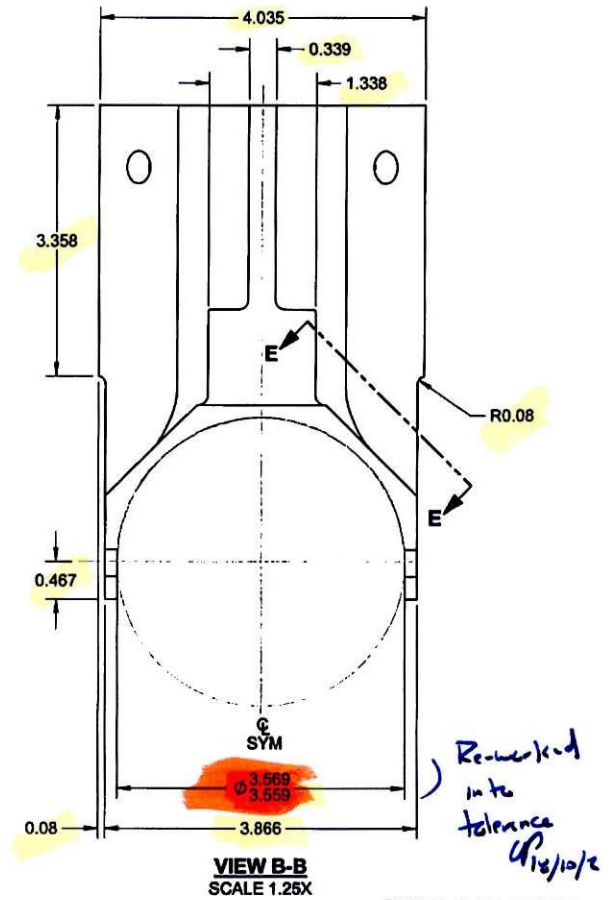
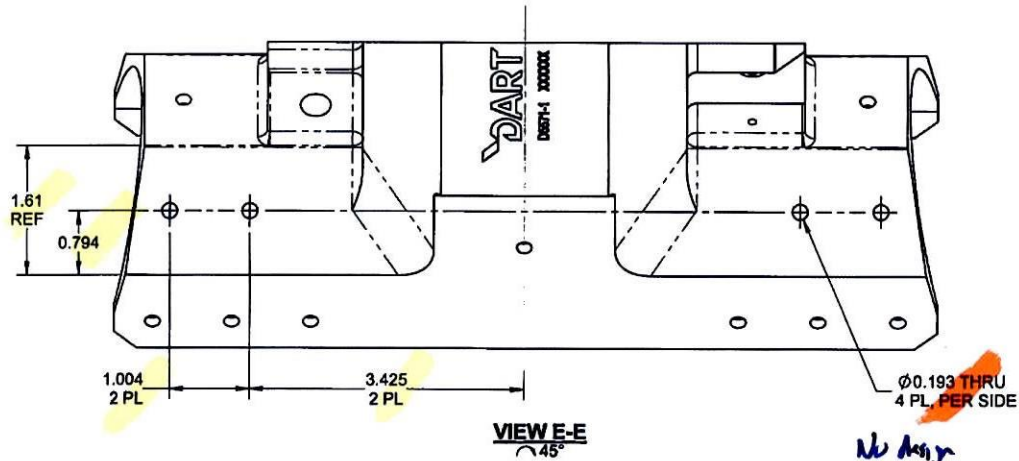
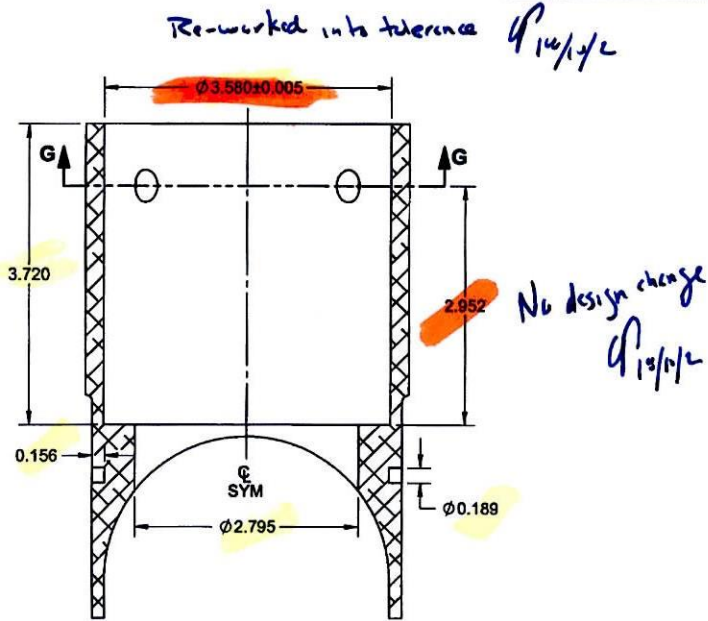
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A	NEW ISSUE	ZF	17.11.30
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	JFS	D5571	SHEET 1 OF 4
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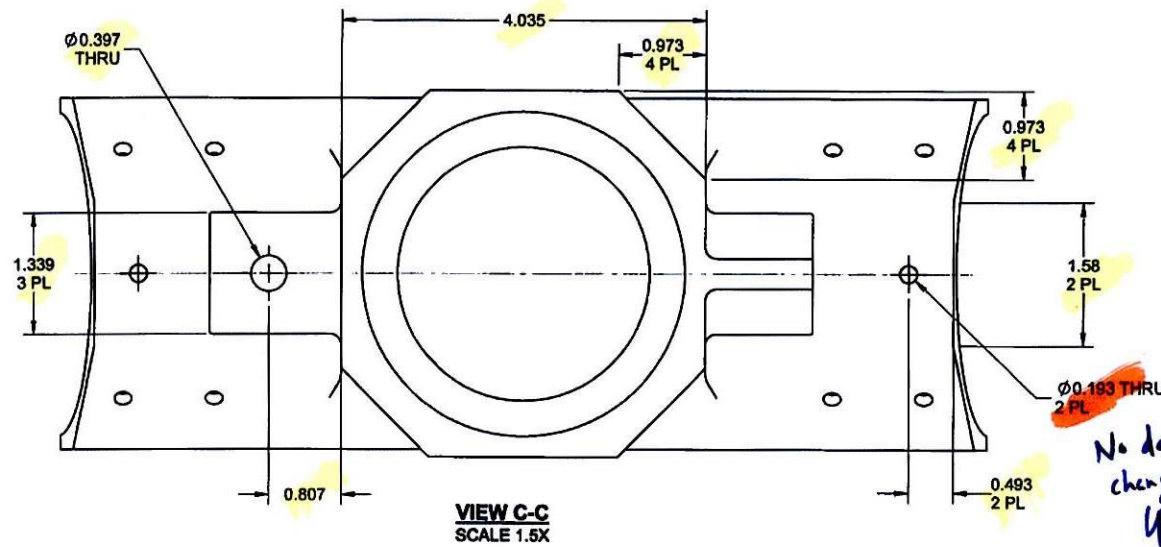
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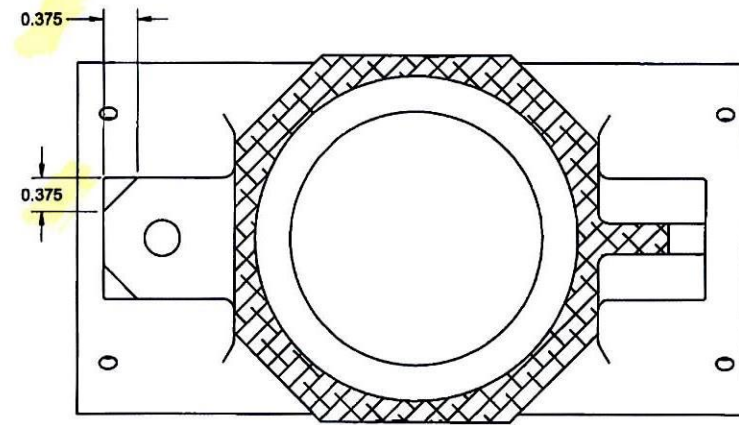
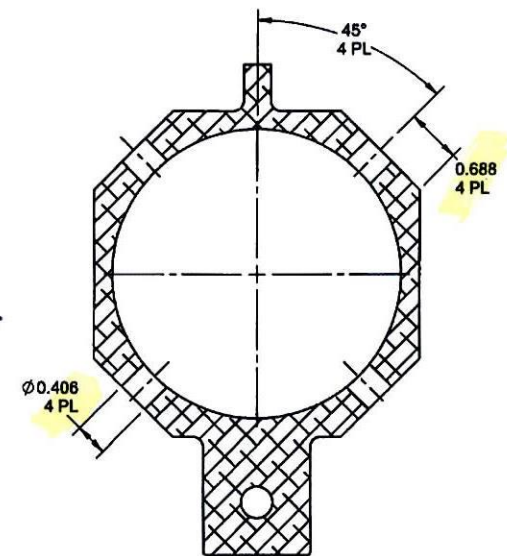
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